



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

Handwritten initials: JSA

D3859-041
Job Sheet 169239



Part No: D3859-041

Job Qty: 6 ea

Part Name: Wearplate Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 12/5/17

Job Tracking No:

Due Date: 12/22/17

Created By: Linda Lacelle

Type: SOLD

Description:

Customer: Air Methods Corporation (CAMET01)

7301 South Peoria Street Englewood, CO, 80112 USA ph:(303) 792-7400

Note: D3859 REV.C IPP Rev:A 09-02-03 new issue DD verified by:EC IPP Rev:B 14.04.30 as per dwg rev.b DD verified by:JLM IPP REV:C 17.11.17 AS PER DWG REV.C DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		12/21/17	0.00	0.00	Start Up Waterjet		<i>EC</i>
100	Waterjet	6 pcs		12/21/17	0.00	0.92	Waterjet1		<i>SC</i>
110	QC	6 pcs		12/21/17	0.00	0.00	QC2 Waterjet-2		<i>SC</i>
120	QC	6 pcs		12/21/17	0.00	0.00	QC8-3		<i>38</i>
130	Large Fab	6 pcs		12/22/17	0.00	10.17	Large Fab 1		<i>100 9-80</i>
140	QC	6 pcs		12/22/17	0.00	0.00	QC9		<i>CL</i>
150	QC	6 pcs		12/22/17	0.00	0.00	QC5		<i>CL</i>
180	Packaging	6 pcs		12/22/17	0.00	0.00	Packaging3 Large Fab		<i>AN ST610</i>
190	QC21-SA	6 Ea		12/22/17	0.00	0.00	QC21		<i>AN</i>

Part Op **100** - 1-Cut as per Dwg D3859-1 Dwg Rev: *C* Prog Rev: *C* 2-Deburr if necessary
Descriptions: **130** - 1-Weld D4379-5 cups as per dwg D3859 A/R 316L stainless steel rod *****use DT9462 for welding***** 2- WELD
HARDCOAT TO BAR 2059B HARDCOAT BATCH: _____ 3- POLISH WELS SURFACE AREA AS PER DWG
NOTE2

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M304S16GA	5	107	0	0
130-Large Fab	D4379-5	36	53	0	0

5017845

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date: _____		DISPOSITION Rework ☐ Skid-tube ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Cross tube</td><td>Water Jet</td><td>Engineering</td></tr> <tr> <td>1 Fab</td><td>Prod. Eng. Coord.</td><td>Quality</td></tr> <tr> <td>Shing</td><td>Rec/Store/Packaging</td><td>Other</td></tr> <tr> <td>osite</td><td>Supplier</td><td></td></tr> </table>				Cross tube	Water Jet	Engineering	1 Fab	Prod. Eng. Coord.	Quality	Shing	Rec/Store/Packaging	Other	osite	Supplier																																																																													
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DART AEROSPACE S018215 Wearplate Assembly		Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K64 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com		MRB (QSI042) Approval _____																																																																																											
PART NO: D3859 - 041 Revision: Operation: Change No: Start up Operation Mfg Date: 12/06/17 Job No: 169239						Completed By _____ and / Supervisor _____ ral Verification _____ A Coordinator _____ approval _____																																																																																									
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1692391

FIRST ARTICLE INSPECTION CHECKLIST

[illegible]

Measured by:	SL	Audited by:	38	Preliminary Approval:	
Date:	17/12/05	Date:	DEC 17 2017	Date:	

Rev	Date	Change	Revised by	Approved
A	09.05.20	New Issue	KJ	
B	14.11.13	Dwg Rev updated	KJ	

DQA: _____ Date: _____



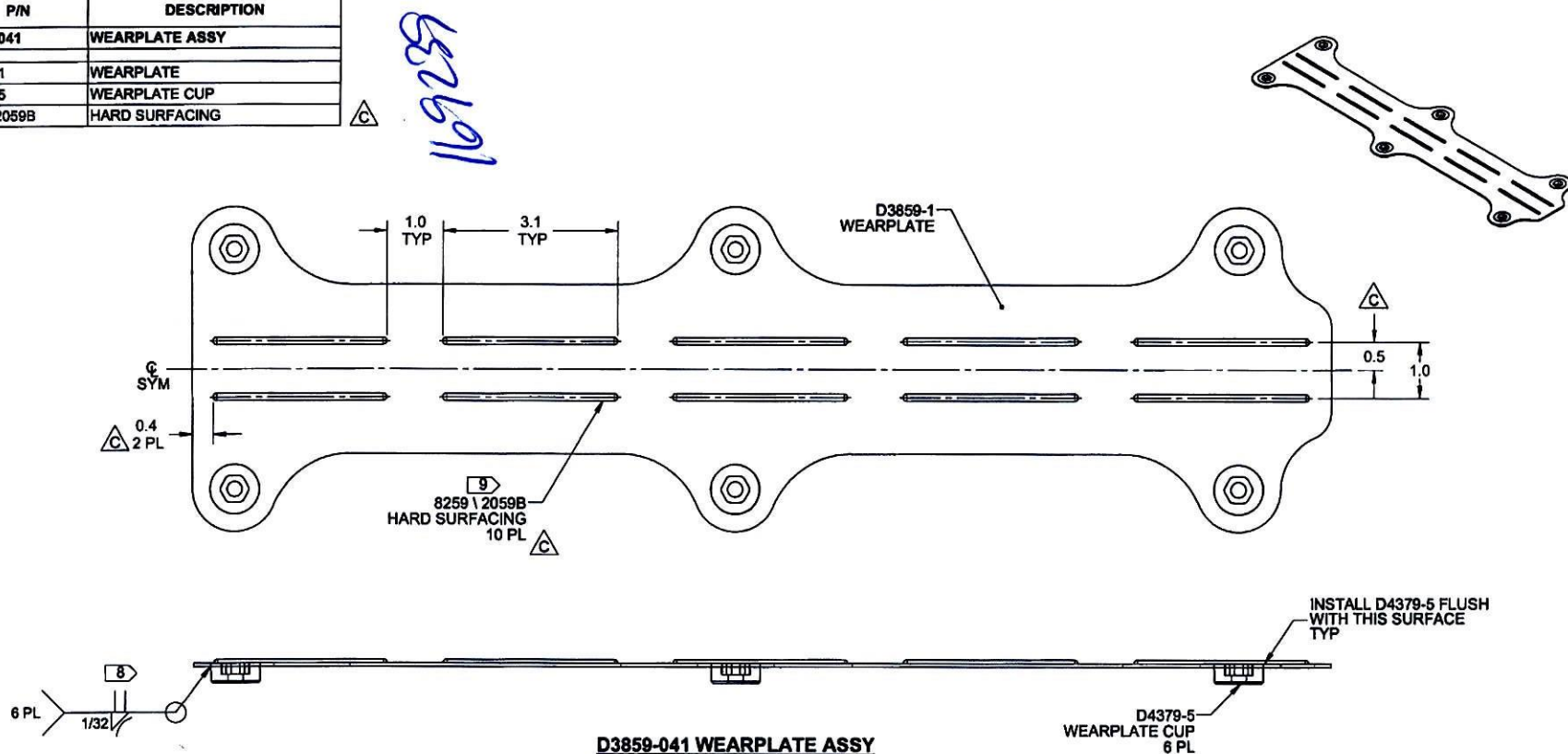
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3859-041	WEARPLATE ASSY
1	1	D3859-1	WEARPLATE
2	8	D4379-5	WEARPLATE CUP
3	A/R	8259 \ 2059B	HARD SURFACING



D3859-041 WEARPLATE ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POLISH WELD SURFACE AREA
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.58 lbs
- 8) WELD PER DART QSI 004
- 9) APPLY HARD SURFACING WELD BEAD 0.06 - 0.13 THICK USING 8259 ROD PER QSI 004 SECTION 4.5 (AUTOMATED WELDING) OR APPLY HARD SURFACING WELD BEAD 0.06 - 0.13 THICK USING 2059B ROD PER QSI 004 SECTION 4.1 (MANUAL WELDING)

RELEASED
2017-11-15
52N 17-750

C	SHEET 1: ADDED NOTE 9 FOR AUTOMATED WELDING. UPDATED NOTE 2 FOR POLISHING WELD, UPDATED WELD SPACING DIMENSIONS. SHEET 2: GENERAL TOLERANCES FOR .1 UPDATED, UPDATED MATERIAL, UPDATED FLAT PATTERN DIMENSIONS.	SAD	16.12.07
B	D4379-5 CUP WAS D3009-3 CUP	DB	14.03.05
A	NEW ISSUE	HS	09.01.26
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SAD		
CHECKED	AJS	DRAWING NO.	REV. C
MFG. APPR.	DD	D3859	SHEET 1 OF 1
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	WEARPLATE	NTS
DATE	16.12.07	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DQA: _____ Date: _____

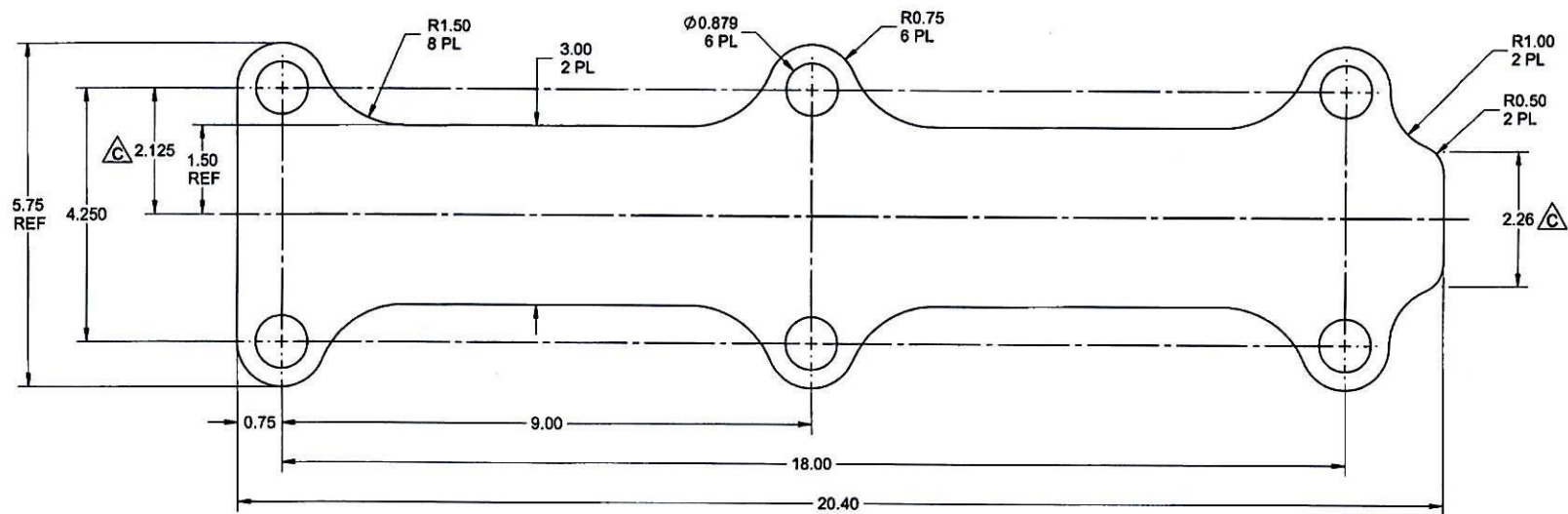


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					



D3859-1F WEARPLATE

NOTES:

1) MATERIAL: AISI 304/316 SS SHEET ANNEALED 16 GAUGE 0.063 THICK
PER MIL-S-5059 OR AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240
REF DART SPEC. M304S16GA

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: 1.29 lbs

RELEASED
2017-11-15

APPROVED

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	SAD	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AJS	DRAWING NO.	REV. C
MFG. APPR.	DD	D3859	SHEET 2 OF 2
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	WEARPLATE	NTS
DATE	16.12.07	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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OTHER : _____					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3912-041
Job Sheet 169293



Part No: D3912-041

Job Qty: 20 ea

Part Name: Eyebolt Receiver Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 12/6/17

Job Tracking No:

Due Date: 12/15/17

Created By: Mario Poulin

Type: SOLD

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea	12/14/17	12/14/17	0.00	0.00	Start Up Stores/Pkg-1		
100	Packaging	20 pcs	12/14/17	12/14/17	0.00	0.00	Packaging1-4		
110	Small Fab	20 pcs	12/15/17	12/15/17	0.00	1.25	Small Fab-5		
120	QC	20 pcs	12/15/17	12/15/17	0.00	0.00	QC5		
170	Packaging	20 pcs	12/15/17	12/15/17	0.00	0.00	Packaging3-2		
180	QC21-SA	20 Ea	12/15/17	12/15/17	0.00	0.00	QC21		

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D3801-1	20/10	0	0	0
	D3912-1	20/10	3	0	0
	D3912-3	40/20	6	0	0
	D3912-5	40/20	5	0	0
	MS20615-4M20	160/80	101	0	0
	MS21209-F615	20/10	50	0	0
	NAS1149C0663R	20/10	101	0	0

Part Specifications

Specifications could not be found.

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Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																		
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Large Fab ☐	Composite ☐	Supplier ☐																			
Date : _____		QTY Effective : _____		MRB (QSI042) Approval																	
Description		Disposition																			
Job No: 169293 Mfg Date: 12/28/17 Start up Operation D3912-041 PART NO: Revision: Operation: Change No: Eyebolt Receiver Assembly S027147 DART AEROSPACE DART Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com		Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																			
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